Rush - Ship Friday

Work Order ID 105526 *105526*

August-08-13 8:57:49 AM

Item ID: D2562-001 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Strut 19.68" **Stop** *NS2*

Start Date: 8/08/13 **Start Qty:** 5.00 *5* **Cust Item ID:**

Required Date: 8/08/13 **Req'd Qty:** 5.00 *5* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 13-08-09 **Tooling:** ______ **Date:** ______

Stop *NR2*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2562	Rev D

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Brake NC Brake NC	NC BRAKE Memo Punch to length as per Dwg D2562 cut at 19.93	0.00 0.00				5			SP 13/10/03 SP 13/10/03
110 *110* Small Fab Small Fab	Small Fab Memo 1- Bend end as per Dwg D2562 Angle "D"2-Deburr	0.00 0.00				5X			SP 13/10/03
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(5)	13-10-03		DAS 09

DQA: ________ Date: ______________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______________

Part No. ______________

NCR No. ______________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 105526 *105526*

August-08-13 8:57:49 AM

Item ID:	D2562-001	**Accept**	*N900040100*	**Setup Start**	*NS1*
Revision ID:				**Stop**	*NS2*
Item Name:	Strut 19.68"				
Start Date:	8/08/13	**Start Qty:** 5.00	*5*	**Cust Item ID:**	
Required Date:	8/08/13	**Req'd Qty:** 5.00	*5*	**Customer:**	
Reference:					

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating W126125	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00				5X	/		ML 13/10/03
	Memo START TIME: 2:00 FINISH TIME: 4:00 OVEN TEMPERATURE: 2:30	0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish	0.00				5x	/		ML 13/10/02
	Memo	0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: ST252	0.00				5X	/		DAS 28 13-10-03
	Memo 1xPPP103439	0.00							

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ______	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
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☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		______
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		______
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		______
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 105526
August-08-13 8:57:49 AM

105526

Item ID: D2562-001
Revision ID:
Item Name: Strut 19.68"

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 8/08/13 **Start Qty:** 5.00 *5*
Required Date: 8/08/13 **Req'd Qty:** 5.00 *5*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ____________ **Date:** ________
QC: ____________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160 QC Quality Control	Memo	0.00				MCJ		13-10-04	

MCJ 13-10-04

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
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☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
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☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

August-08-13 8:57:49 AM

Work Order ID: 105526

Parent Item: D2562-001

Parent Item Name: Strut 19.68"

Start Date: 8/08/13 **Required Date:** 8/08/13

Start Qty: 5.00 **Required Qty:** 5.00

Comments: IPP F02.04.15Added dwg Rev.B1 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035 304 RD Tube .500 x .035W		Purchased	No			100	f	492.4211	**1.7067**	**8.9826315**		8/10/13	

Location		Loc Qty	Loc Code
MAT017		492.42113	
	118702	0.00003	
	123303	138.9645	
	125513	353.4566	

8.9826315

DQA: ________ Date: ______________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

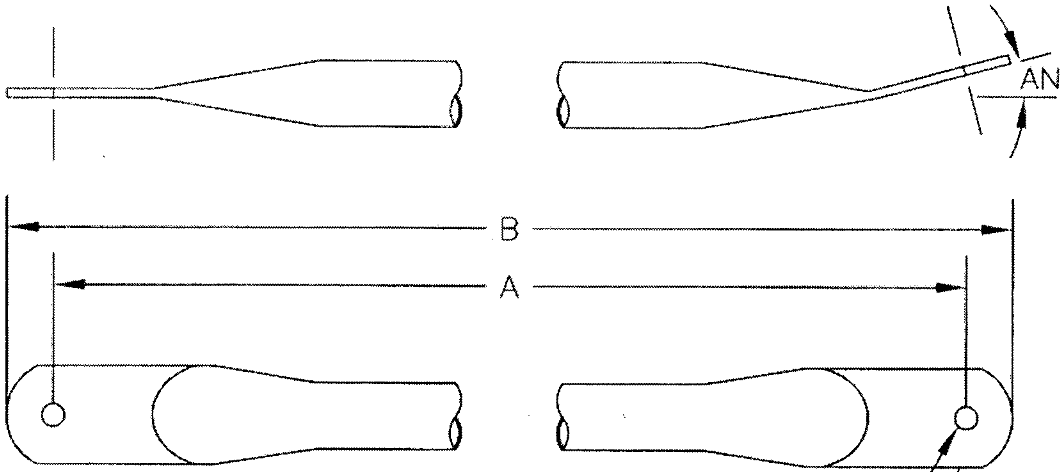
QA Closed: Date:

Work Order: ______________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ______________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling ☐									
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Material ☐									
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Process ☐									
Supplier ☐									
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FAULT CATEGORY

Landing Gear	**General**			
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PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	–	10
D2562-003	20.37	21.17	–	18
D2562-005	29.00	29.80	–	30
D2562-007	19.22	20.02	–	0
D2562-011	25.79	26.59	–	16
D2562-013	26.63	27.43	–	24

GENERAL NOTES

1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

RELEASED 05-05-27

NO. 105526 MLS 13-08-09

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV.
CP	RF	D2562	D
CHECKED	APPROVED	TITLE	SHEET 1 OF 1
DATE 05.05.18		STRUT	SCALE 1:2

REV	DATE	DESCRIPTION
A	96.05.01	NEW ISSUE
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)
C	02.06.05	ADD -005; ADD FINISH
D	05.05.18	ADD -007/-011/-013; UPDATE -005

DART AEROSPACE LTD

Description: Strut	Work Order: 105526
Inspection Drawing: Rev: D	Part Number: 2562-001

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
19.68	+/- .030	19.710	✓		T	SBS
20.48	+/- .030	20.510	✓		T	SBS
ang 10°	+/- ½°	10°	✓		angle meter	SPAB-01

Measured by: SB	Checked By: SB	QC inspector: DAS 09	Engineering Approval (*if necessary*):
Date 13/10/03	Date 13/10/03	Date 13.10.03	Date